

Date: Wednesday, 28/05/2008 9:57:55 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 412 X-TUBE INST,LOW NARROW FWD		
Job Number	: 39534		Part Number	: D412664105		
Estimate Number	: 12816		Drawing Number	: D412-664-145 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 28/05/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 02/06/2008 Qty: 1 Um: Each		
Previous Run	: 37956					
Written By	:					
Checked & Approved By	: JUN 08.5.28					
Comment	: Est Rev:A New Issue 07-04-05 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-105 CHG001 <i>S 08.5.28</i>
2.0	PACKAGING 1	PACKAGING RESOURCE#1
		Comment: PACKAGING RESOURCE #1
3.0	D412664105TRN	CROSSTUBE TURNING DETAIL
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) CROSSTUBE TURNING DETAIL batch B38012 <i>DP 8-5-28</i>
4.0	BENDING	BENDING MACHINE - SKIDTUBES
		Comment: BENDING MACHINE Bend tube as per Dwg D412-664-145 using CNC bender program <i>BL 8-5-28</i>
5.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK <i>080528 ①</i>
6.0	CROSSTUBES	CROSSTUBES RESOURCE 1
		Comment: LANDING GEAR RESOURCE 1 1-Drill pilot holes in tube as per Dwg D412-664-245 2-Ream hole to finish size in tube as per Dwg D412-664-245 <i>PTO</i> <i>BT 08.5.29</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/05/28	S.1	Mark cut lines	JK 08/05/28	08/05/28	10	08/05/28	08/05/28	
08/05/28	S.2	- Scribe tube - Cut tube to height as per dim sheet.	JK 08/05/28	08/05/28	10	08/05/28	08/05/28	
08/05/28	S.3	QC 15 inspect cut	JK 08/05/28	08/05/28	10	08/05/28	08/05/28	
08/05/28		make changes permanently	JK 08/05/28	08/05/28	10	08/05/28	08/05/28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 9:57:55 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 412 X-TUBE INST,LOW NARROW FWD
Job Number: 39534		Part Number: D412664105
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245		
7.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat Tube as per QSI 005 4.1		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
9.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		
10.0	OUTSIDE SERV.10 	OUTSIDE SERVICES-skids 
Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 0380r Issue P/O: 6471 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		
11.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order.		
12.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: Inspect for damage & ensure results are as per Dwg D412-664-203		
13.0	SPRAY PAINTING 	SPRAY PAINTING 
Comment: SPRAY PAINTING		
1-Prime inside and outside crosstube as per QSI 005 4.2		
2-Paint outside crosstube with White Imron as per QSI 005 4.2		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 412 X-TUBE INST,LOW NARROW FWD
Job Number: 39534		Part Number: D412664105
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
14.0	QC14	INSPECT SPRAY PAINT 
15.0	D31893	Chafing Shield 
Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches		RT 08-06-03
16.0	D3595063450	RUBBER CUSHION 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Chafing Shield Batch: 31656		M 08 06 05
17.0	D28931	2.75 Support 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Rubber Cushion Batch: 38618		RT 08-06-03
18.0	D2856600	Abrasion Strip 
Comment: Qty.: 0.9450 f(s)/Unit Total : 0.9450 f(s) Abrasion Strip 1X D2856 .250" X 8.42" Batch: 35900		M 08 06 05
19.0	MS2192024	Clamp(per MIL-DTL-8783C) 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) clamp(per MIL-DTL-8783C) batch: 107441		M 08 06 05
20.0	MS2192025	Clamp(per MIL-DTL-8783C) 
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Clamp(per MIL-DTL-8783C) Batch: 107973/107975*3		RT 08-06-03

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 X-TUBE INST,LOW NARROW FWD

Job Number: 39534

Part Number: D412664105

Job Number:



Seq. #: Machine Or Operation:

Description :

21.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-145

1-Install Chaffing Shield

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Instal supports with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application: 4:06 08-06-03

Batch: 107 621

BT
08-06-03

22.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/05

23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0 AN635A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 107178

AS 08/06/05 (X)

25.0 AN636A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 107534

AS 08/06/05 (X)

26.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: 1065077

AS 08/06/05 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39534
Description: Crosstube Assembly (412 Low Narrow Fwd)	Part Number:	D412-664-145
Inspection Dwg: D412-664-145 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

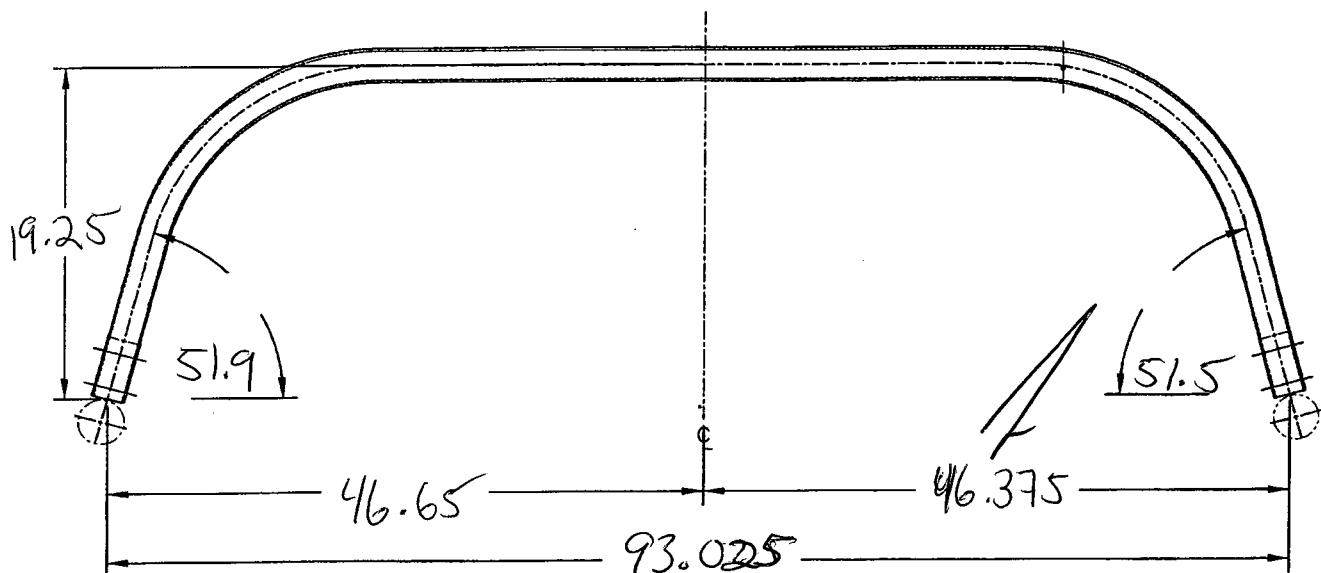
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.740	+0.005/-0.000				
	2.490	+0.005/-0.000				
	2.557	+0.005/-0.000				
	2.624	+0.005/-0.000				
	2.692	+0.005/-0.000				
SIDE B	2.740	+0.005/-0.000				
	2.490	+0.005/-0.000				
	2.557	+0.005/-0.000				
	2.624	+0.005/-0.000				
	2.692	+0.005/-0.000				
124.48		+/-0.020				

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue (P/O D412-664-105)	KJ/DD	

DART AEROSPACE LTD	Work Order:	39534
Description: Crosstube Low Narrow Fwd (412)	Part Number:	D412-664-105
Inspection Dwg: D412-664-145	Rev: C	Page 1 of 1

Required Dimension	Min	Max
Height	19.23	19.49
1/2 Span	46.47	46.73
Angle	49°	52°
Total Span	92.94	93.46



Comments

QC15 Inspection	<i>[Signature]</i>
Date	0805-28

Rev	Date	Change	Revised by	Approved
A	07.04.27	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D412-664-145	SHEET 1 OF 3
DATE		TITLE	
07.03.29		SCALE	
		CROSSTUBE ASS'Y (412 LOW-N FWD) NTS	
A	06.12.21	NEW ISSUE	
B	07.03.01	CHG RUBBER CUSHION	
C	07.03.29	CHG CLAMP & RUBBER CUSHION LGTH.	

RELEASED07.04.24 ~~✓~~**PARTS LIST:**

Qty	Part Number	Description
X	D412-664-145	CROSSTUBE ASSEMBLY (412 LOW-NARROW FWD)
1	D6019-128	CROSSTUBE
1	D2856-250-842	ABRASION STRIP
2	D2893-1	SUPPORT
1	D3189-3	CHAFING SHIELD
4	D3595-063-450	RUBBER CUSHION
2	MS21920-24	CLAMP
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

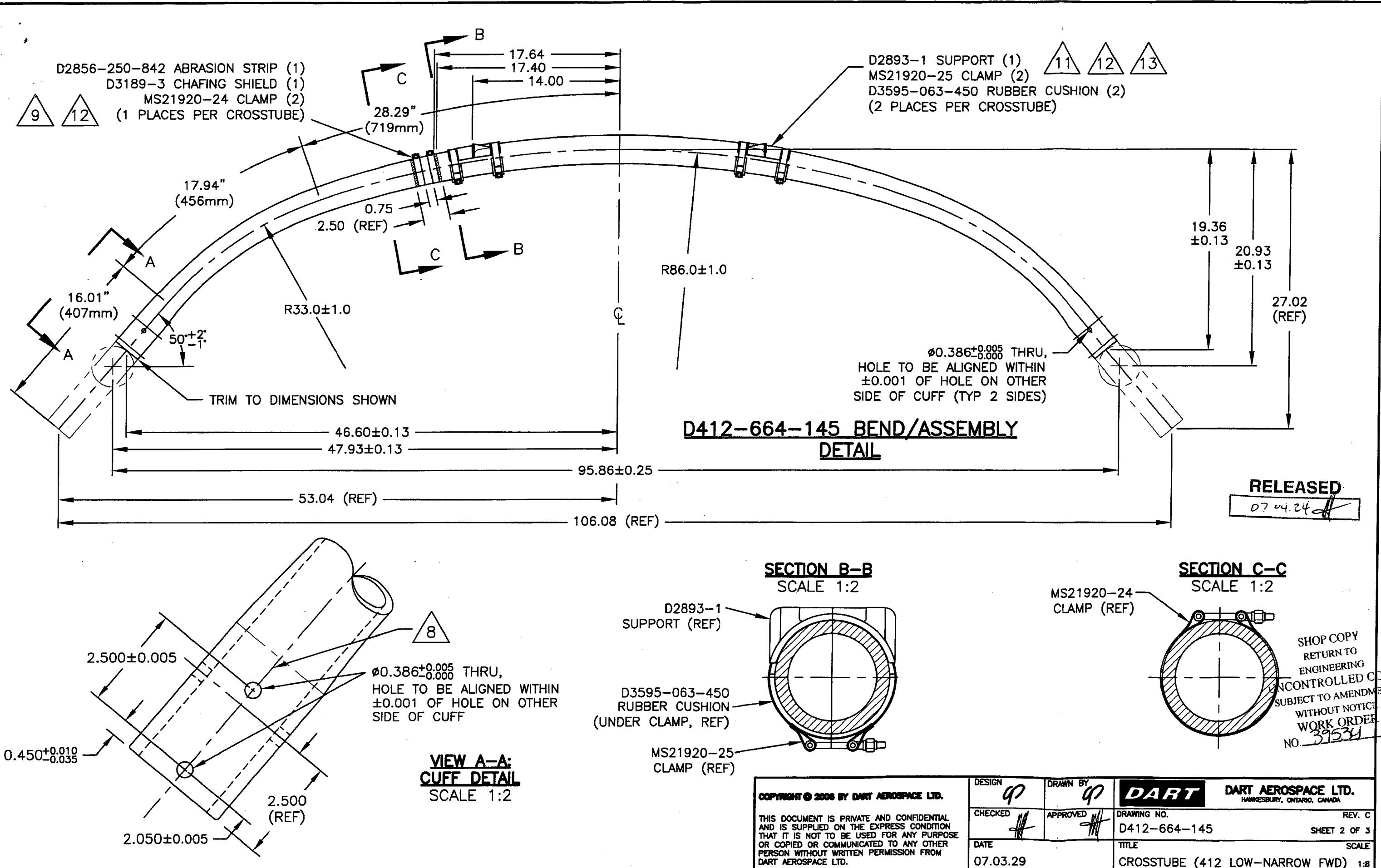
GENERAL NOTES:

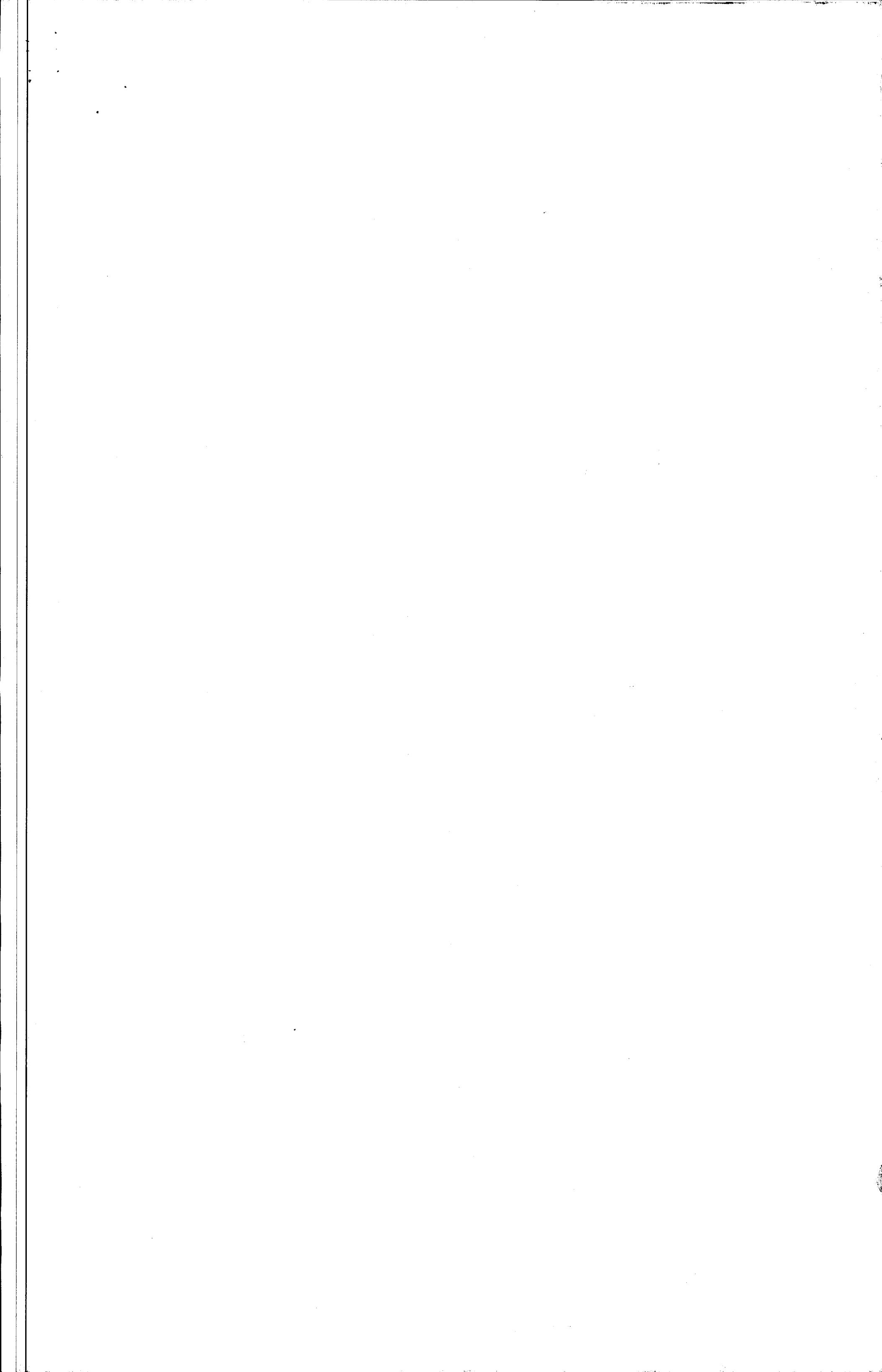
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 124.48 ± 0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR D3189-3 CHAFING SHIELD AND ASSOCIATED HARDWARE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-XXX-YYY ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER **SHOP COPY**
INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE **ENGINEERING**
CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN **SAFETY**
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

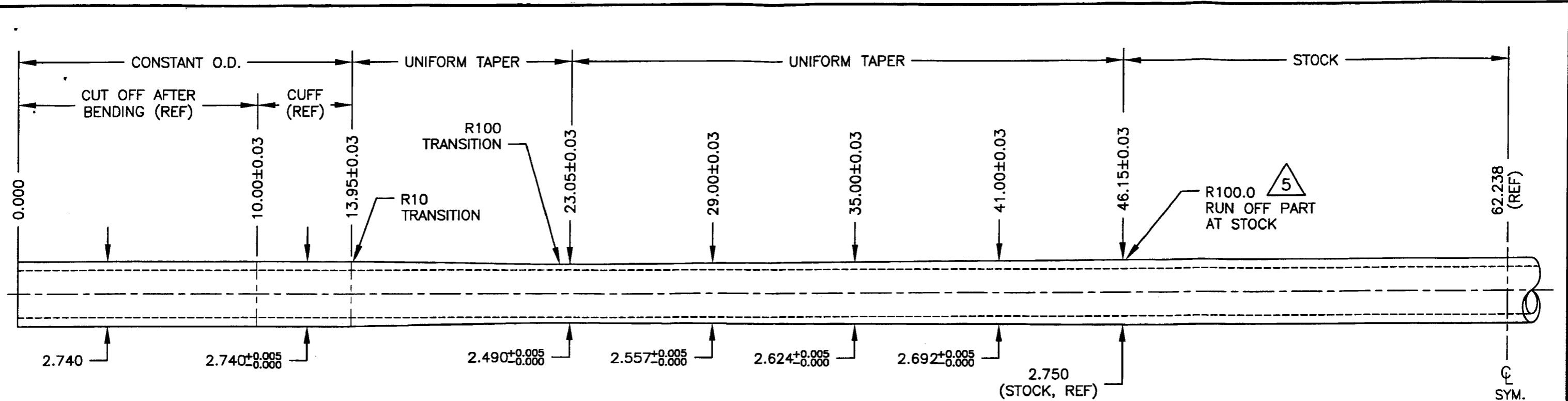
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39534

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D412-664-145 MACHINING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
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NO. 39534

RELEASED

07.04.1988

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED		DRAWING NO.
			D412-664-145
DATE		TITLE	SCALE
07.03.29		CROSSTUBE (412 LOW-NARROW FWD)	1:4

LIQUID PENETRANT TEST REPORT

P - 1311 1

ACUREN

CLIENT	DART AEROSPACE	DATE	MAY 30, 2008	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 08 1311	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/WO NO.	6471				
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
PROJECT		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
ITEM(S) EXAMINED	412 HIGH AFT X TUBE, 212/205 HIGH AFT X TUBE, 412 LOW NARROW FWD X TUBE, JOB #'S 412-39111(39534)39535, 212/205-39367, 39368..						

JOB DESCRIPTION	PROCEDURE NO. LT-0002 REV./DATE	TECHNIQUE NO. LT-TECH2 REV./DATE
'PART NO. D412664203/D212664201/D412664105	MATERIAL ALODINED ALUM.	THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE		

TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc		
PENETRANT ZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
PENETRANT REMOVER H ₂ O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL MAY 1 08			
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE			
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY				

TEST SURFACE							
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL		
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F		<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F		
RESULTS-	<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL						

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

212/205 HIGH AFT X TUBE JOB#: 39367,39368.

412 HIGH AFT X TUBE JOB#: 39111.

412 LOW NARROW FWD X TUBE JOB#: 39534)39535.

M 08 06 02

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE			DTR # E 19676
TECHNICIAN (SIGNATURE):	PRINT: <i>Jason Hewett</i>	SIGNATURE	REPORT REVIEWED BY:
NAME (PRINT):	JASON HEWETT	1 ST TECHNICIAN	
CGSB LEVEL	2	SNT LEVEL	NAME INITIALS
CGSB REG. NO.	6156	CGSB LEVEL SNT LEVEL	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

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P.O. Number	:			Project Number	: N/A		
This Issue	: 28/05/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : CROSSTUBES			Due Date	: 02/06/2008 Qty: 1 Um: Each		
Previous Run	: 37956						
Written By	:						
Checked & Approved By	: <u>CDW 08.5.28</u>						
Comment	: Est Rev:A New Issue 07-04-05 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL <i>JWP 08.5.29</i> Photocopy bluefile and create labels as per PPP D412-664-105 CHG001	
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
3.0	D412664105TRN	CROSSTUBE TURNING DETAIL	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) CROSSTUBE TURNING DETAIL batch	
4.0	BENDING	BENDING MACHINE - SKIDTUBES	
		Comment: BENDING MACHINE Bend tube as per Dwg D412-664-145 using CNC bender program	
5.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
6.0	CROSSTUBES	CROSSTUBES RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Drill pilot holes in tube as per Dwg D412-664-245 2-Ream hole to finish size in tube as per Dwg D412-664-245	